

Date: Monday, 2/11/2008 11:40:19 AM  
 User: Kim Johnston

## Process Sheet

9

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER INSTALLATION  
 Job Number : 37319  
 Estimate Number : 12188  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : LARGE FAB ASSY  
 Previous Run : 37049  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM

Part Number : D205706013  
 Drawing Number : N/A  
 Project Number : N/A  
 Drawing Revision : N/A  
 Material :  
 Due Date : 2/27/2008 Qty: 3 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D205-706-013CHG001

8086411

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D20014 Valve 1/4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
 1 D2001-4 Valve Assembly 32197

S  
+3

C

4.0 D3262041 Fuel Purge Canister



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
 1 D3262-041 Canister Assembly 35133

36777 24 37369 1X

~~35133~~ 37293 1X

C

5.0 D32641 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch  
 2 D3264-1 Bracket 35133

\*  
34243 1X 16/3/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:40:19 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 37319

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D329710121

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Hose Ass'y

Qty Part Number Description Batch  
1 D3297-1-0121 Hose Assembly 35135 1X

B38057 2X / 8/4/11  
W

7.0

D329710130

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Hose Ass'y

Qty Part Number Description Batch  
1 D3297-1-0130 Hose Assembly 37675 2X

B38060 1X  
W

8.0

D329730350

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Hose Ass'y

Qty Part Number Description Batch  
1 D3297-3-0350 Hose Assembly 37676 1X

B38061 2X / 8/4/11  
W

9.0

D3298001

Tube Assembly 25"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Pick: Packing Kit

Qty Part Number Description Batch  
1 D3298-001 Tube Assembly 35136

W

10.0

D3298009

Tube Assembly 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Pick: Packing Kit

Qty Part Number Description Batch  
1 D3298-009 Tube Assembly 35137 1X

33068 1X 38063 1X  
B33068 1X  
W

11.0

D32991

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)  
Pick: Packing Kit

Qty Part Number Description Batch  
1 D3299-1 Fitting 35138

W 8/3/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/11/2008 11:40:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 37319

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D32993

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting 35739

13.0

D33011

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-1

Placard 37077

14.0

D33013

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-3

Placard 23305

15.0

D33021

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler 35129

16.0

D33023

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-3

Doubler 34245 2X

12814/9  
B 38064

17.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-5A

Bolt M100188

1283/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:40:19 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 37319

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN8146D

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN814-6D

Plug

M17710

19.0

AN8156D

Union-M-Flare



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN815-6D

Union

M17654

20.0

AN8336D

Elbow, Bulkhead-M-Flare



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 AN833-6D

Elbow

M105978

21.0

AN9246D

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN924-6D

Nut

M104374

22.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 AN960JD10

Washer

M106552

23.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

M104885

P-8/3/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Monday, 2/11/2008 11:40:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 37319

Part Number: D205706013

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN960JD10L Washer

24.0

AN960JD916

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN960JD916

Washer

M100857

25.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3

Nut (or -3)

M106883

26.0

MS21919WDG9

Clamp



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS21919WDG9

Clamp

M104715

27.0

MS21919WDG12

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

1 MS21919WDG12

Clamp

M101925

28.0

MS21919WDG16

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clamp

Qty Part Number

Description

Batch

2 MS21919WDG16

Clamp

M105578

M107178

29.0

MS2192042

CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M107216

M107178

2/3/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/11/2008 11:40:19 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER INSTALLATION

Job Number: 37319

Part Number: D205706013

(3)

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

MS287786

Packing



Comment: Qty.: 5.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 MS28778-6

O-Ring

105978 5X

M107891 10X

8/4/11

31.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 MS35489-11

Grommet

16 323

8/4/11

32.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/04/14 (X3)

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD205-706-013

Location:

PPP Rev:

Rev B

8/08/04/11

(X3)

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/15

Job Completion



MF 08-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries